

Work Order ID 69840

Friday, May 20, 2011 8:37:22 AM

Page 1

Item ID: D4012-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Cushion

Start Date: 5/20/2011 Start Qty: 40.00

Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4012

B

100

0.00



Mill Conv

Conventional Milling Machine

Memo

1-Turn as per folio FA & dwg

FOLIO REV:

DWG REV:

2-Deburr as required

Manual

0.00

11/06/01

40

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

11/06/01

40

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69840

Friday, May 20, 2011 8:37:22 AM



Item ID: D4012-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cushion

Start Date: 5/20/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

*mf 11/06/12*

*40*



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: *459*

0.00



Packaging

Memo

0.00

Packaging

*11/6/12 (40)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/12*  
*mf*  
*11-08-03*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, May 20, 2011 8:37:19 AM

Page 1

Work Order ID: 69840



Parent Item: D4012-1

Parent Item Name: Cushion


Start Date: 5/20/2011

Required Date: 5/23/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: New issue 09.10.28 DD verified by:JLM  
revA as per dwg 09.11.18 DD verified by:JLM  
as per dwg Rev.B DD verified by:JLM  
IPP RevB:  
IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3 		Manufactured	No			100	f	6.0000	0.37	15.57895			

UHMW U-Channel

Location

MAT056

Loc Qty

6

Loc Code

6

~~63829~~  
B69841

205+

11/06/01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

61840

## FIRST ARTICLE INSPECTION CHECKLIST

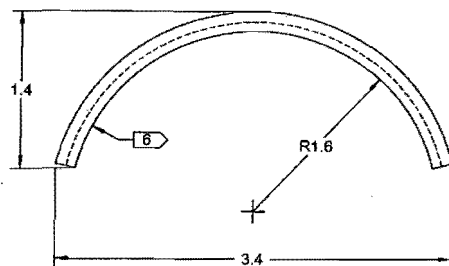
[illegible]

Measured by: 	Audited by: 	Preliminary Approval:
Date: 11/06/01	Date: 11/06/02	Date:

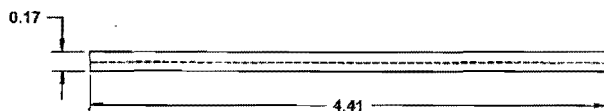
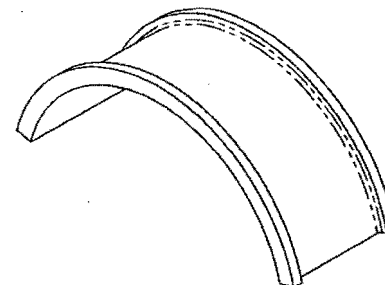
Rev	Date	Change	Revised by	Approved
A	11.01.17	New Issue	KJ	



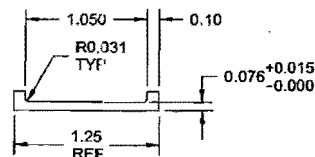




**D4012-1 CUSHION**  
 (MAKE FROM D4012-1F)



**D4012-1F FLAT MACHINED STATE**



**NOTES:**

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

*WLB 69840*

**RELEASED**  
 2010-12-23

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D4012**

REV. B  
 SHEET 1 OF 1

TITLE  
**CUSHION**

SCALE  
 NTS

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